

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018857**Date Inspected:** 24-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

WELDING:**Segment 12AE ~ 12BE**

This QA Inspector observed ZPMC qualified welding personnel identified as 050289 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP3001-001-026; located On Orthotropic Box Girder (OBG) Corner Assembly I-Rib to I-Rib CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-3213-B-U3b.

Segment 12AE ~ 12BE

This QA Inspector observed ZPMC qualified welding personnel identified as 050289 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP3001-001-026; located On Orthotropic Box Girder (OBG) Corner Assembly I-Rib to I-Rib CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. The welding

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

variables recorded by QC appeared to comply with applicable WPS-B-T-3213-B-U3b.

Segment 12AE ~ 12BE

This QA Inspector observed ZPMC qualified welding personnel identified as 047353 perform Flux Core Arc Welding (FCAW), weld joint identified as OBE12B-001; located On Orthotropic Box Girder (OBG) Bottom Plate to Bottom Plate Transverse Splice CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-2231T-ESAB.

NDT:

Segment 11DE

This QA Inspector performed Magnetic Particle Testing (MPT) Verification Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report on this date. The members are identified as Orthotropic Box Girder (OBG) components. The weld designations Verified are as follows.

BP025-001-040, 041
FB019-001-003, 004, 015, 016
SEG071E-056, 057, 104, 105, 131, 132
SSD10A-104-174, 175

Nondestructive testing (NDT) notification No.07907.

Segment 11DW

This QA Inspector performed Magnetic Particle Testing (MPT) Verification Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report on this date. The members are identified as Orthotropic Box Girder (OBG) components. The weld designations Verified are as follows.

BP025-001-038, 039
FB24-001-007, 008, 015, 016
FB28-001-005, 006, 013, 014
SSD18-106-177, 178
SSD17-105-170, 171
SEG072D-158, 159
SEG072E-043, 044

Nondestructive testing (NDT) notification No.07910

Segment 11EE

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This QA Inspector performed Magnetic Particle Testing (MPT) Verification Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report on this date. The members are identified as Orthotropic Box Girder (OBG) components. The weld designations Verified are as follows.

OBE11E-025, 043, 009

FB027-011-128

SSD12A-PP106-169

Nondestructive testing (NDT) notification No.07912.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
